

Work Order ID 51934

September 9, 2009 12:35:06 PM

Page 1

Item ID: D3186-4

Accept

Revision ID: D

Item Name: Spacepod Door, RH

Setup Start

Stop

Start Date: 9/11/09 Start Qty: 1.00

Required Date: 9/18/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3186

Rev ~~X~~ E

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

RT 09.0915

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8/21/09

Ⓟ

120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/9/09 @ SU

Work Order ID 51934

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Page 2

Item ID: D3186-4

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, RH

Start Date: 9/11/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

09/09/23 
MF 09-09-23

Picklist Print

September 9, 2009 12:35:05 PM

Page 1

Work Order ID: 51934

Parent Item: D3186-4RevD

Parent Item Name: Spacepod Door, RH

Comments:

Start Date: 9/11/09

Required Date: 9/18/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3186-2MRevD | | Manufactured | No | | | 100 | Each | 1.0000 | 1.0000 | | | |



SPACEPOD DOOR RH



8T 09-09-09

48150001

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

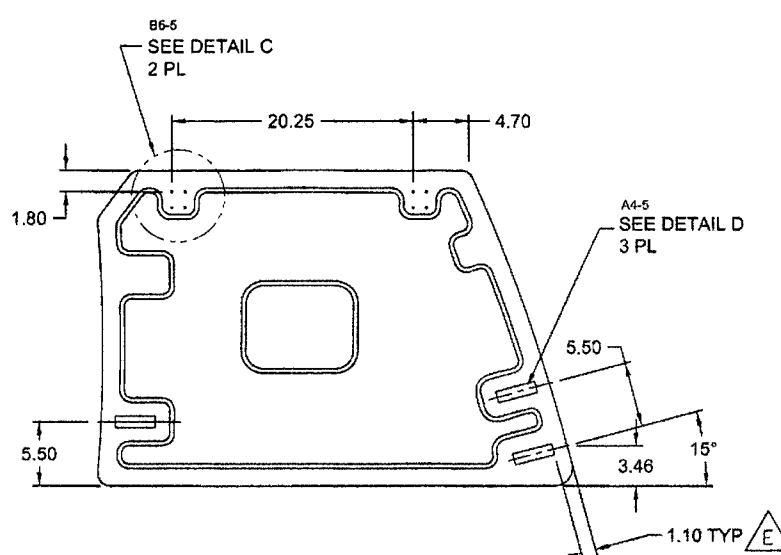
CA

1

47002B01

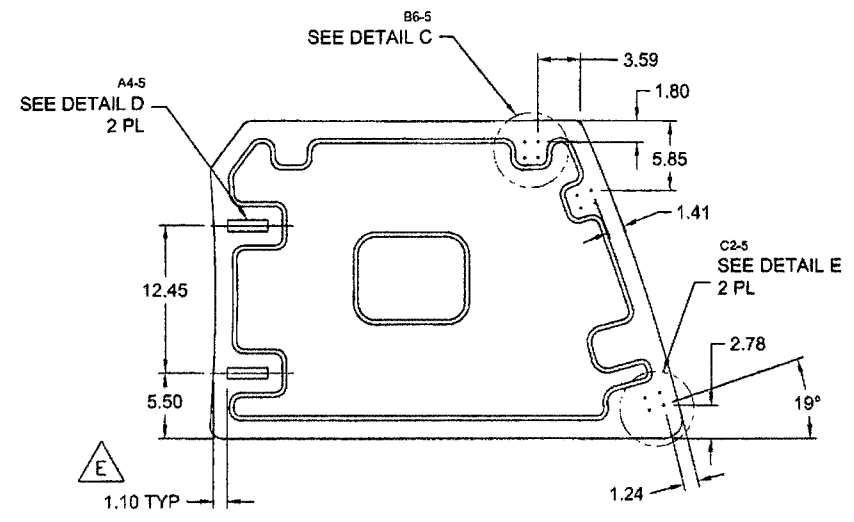
1

8 7 6 5 4 3 2 1



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A



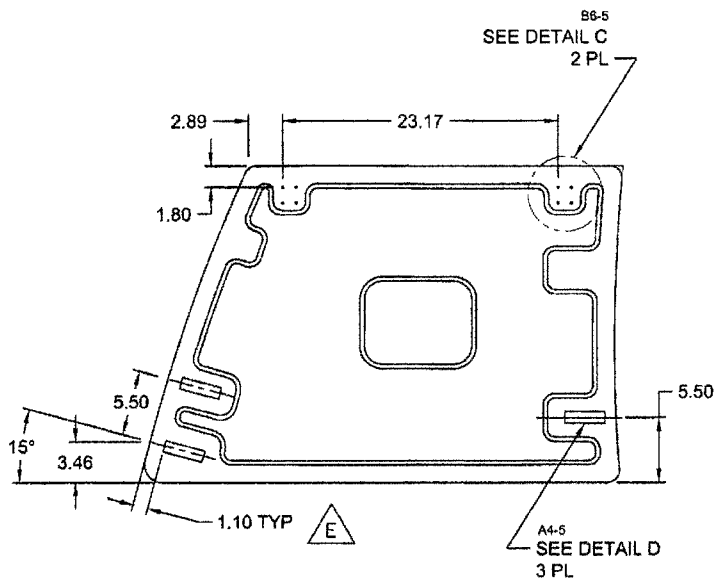
D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

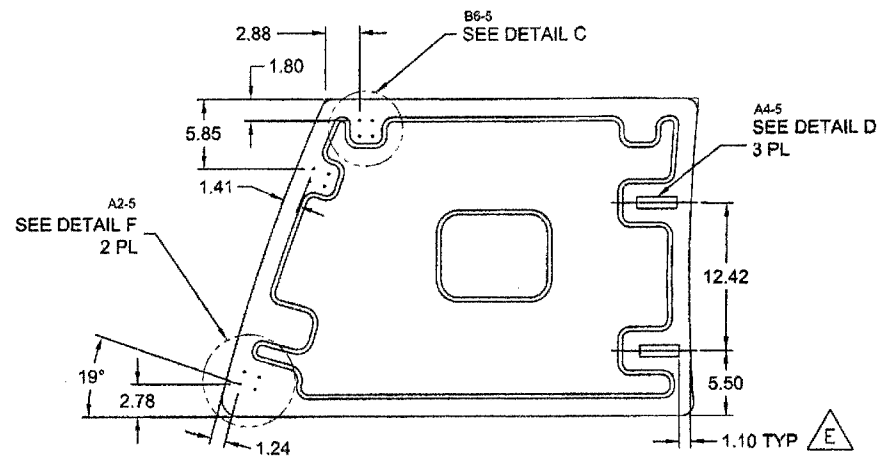
WFO 51934

| REV. | DESCRIPTION | BY | DATE |
|------------|--|---|--------------|
| E | DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.88 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026 | RF | 09.07.08 |
| D | UPDATE DIMENSIONS | LE | 07.02.22 |
| C | REMOVED D0600-XXX LABELS | LE | 06.12.13 |
| B | DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/2M/3/4 ADDED | LE | 06.09.25 |
| A | NEW ISSUE | CP | 03.03.27 |
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV. E |
| MFG. APPR. | RF | D3186 | SHEET 1 OF 5 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | SPACEPOD DOOR | NTS |
| DATE | 09.07.08 | COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

8 7 6 5 4 3 2 1



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

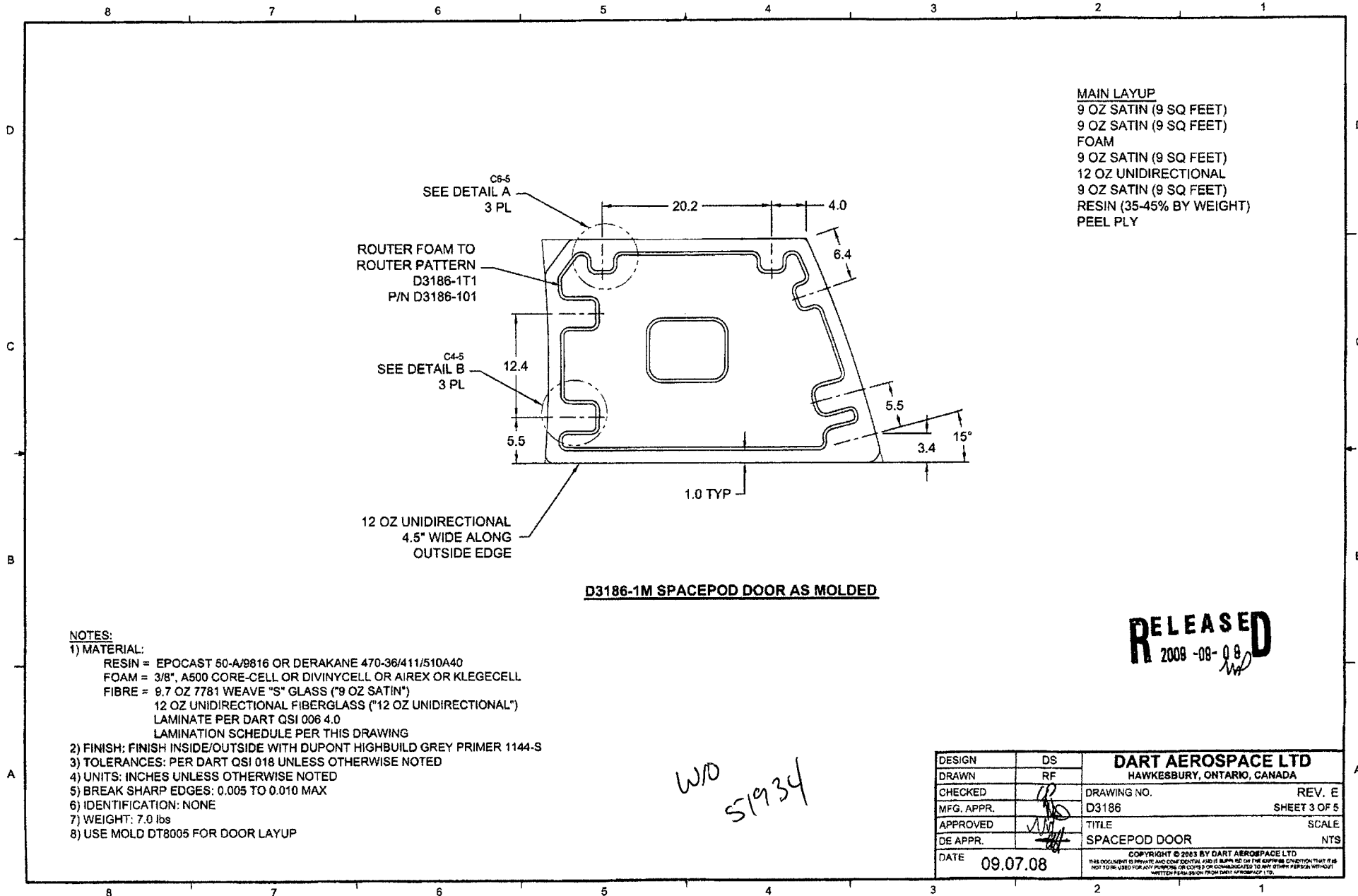
RELEASED
2008-09-09

NOTES:

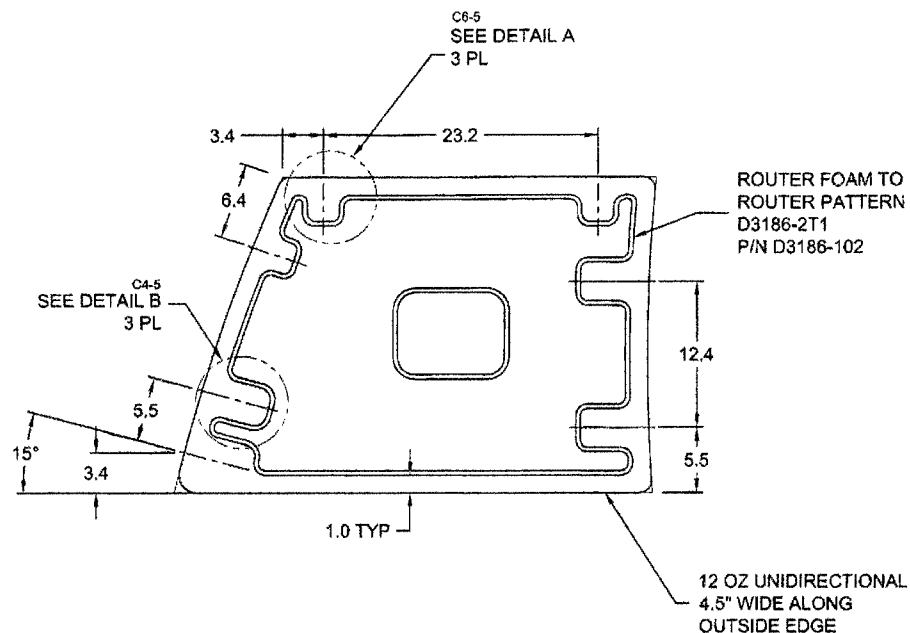
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

WO
51934

| | | | |
|------------|----------|---|--------------|
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | AK | DRAWING NO. | REV. E |
| MFG. APPR. | AK | D3186 | SHEET 2 OF 5 |
| APPROVED | AK | TITLE | SCALE |
| DE APPR. | AK | SPACEPOD DOOR | NTS |
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9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



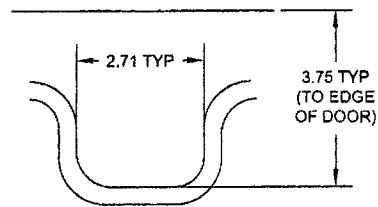
1) MATERIAL:

- RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 7.0 lbs
8) USE MOLD DT8006 FOR DOOR LAYOUT

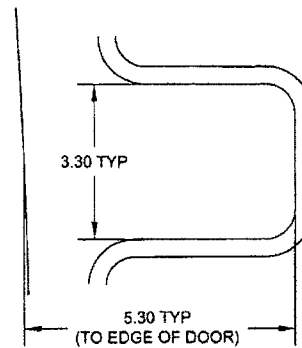
D3186-2M SPACEPOD DOOR AS MOLDED

RELEASE
2009-08-09

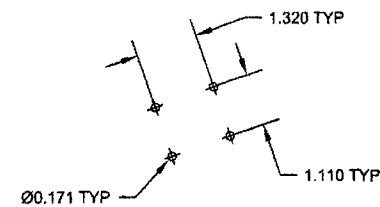
| | | | |
|---------------|--------------------|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | RP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RP | DRAWING NO. | REV. # |
| MFG. APPR. | <i>[Signature]</i> | D3188 | SHEET 4 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SPACEPOD DOOR | NT |
| DATE 09.07.08 | | COPYRIGHT © 2003 BY DART AEROSPACE LTD. <small>THIS DOCUMENT AND ITS CONTENTS ARE UNCLASSIFIED AND ARE BEING RELEASED TO THE PUBLIC ON THE BASIS OF THE POLICY THAT IT DOES NOT BELONG TO ANY PERSON OR COMPANY OR COMMUNITIES TO ANY OTHER PERSON OR ENTITY WHOSE INTERESTS ARE NOT BEING PROTECTED BY THIS ACT.</small> | |



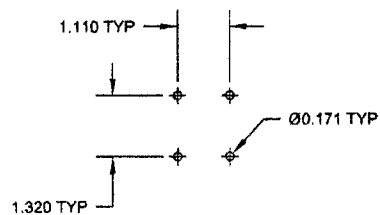
DETAIL A D6-3
SCALE 4X D4-4



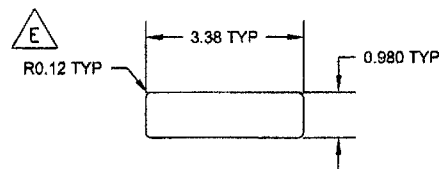
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

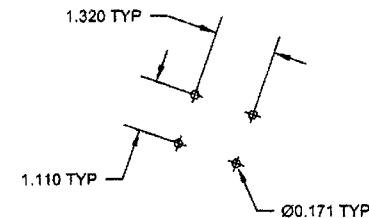


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-09

W10
51934

| | | | |
|--|--------------------|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. E |
| MFG. APPR. | <i>[Signature]</i> | D3186 | SHEET 5 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SPACEPOD DOOR | NTS |
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